

## **CORODUR<sup>®</sup> 495**

### **CLASSIFICATION:**

DIN EN 14700    DIN 8555  
T Z Fe8        MF 3-50-CKTZW

### **GENERAL CHARACTERISTICS:**

The rust-free weld deposit on Fe- Cr- Ni- Co- Mo- base has a high hot wear resistance, tensile strength and a high resistance to sliding wear of metallic objects. It has a good retention of hardness up to 650° C and is nonscaling up to 900° C, thermal shock resistant and resistant to sudden changes of temperature, work hardening, not crack sensible.

### **APPLICATION:**

Hardfacing of forging presses, hot piercing dies, stretching rolls, pinch rolls, hot strip mill table rolls and back-up rolls.

### **TYPICAL ALL WELD METAL ANALYSIS ( % ):**

C	Si	Mn	Cr	Ni	Mo	Co
0,1	0,7	0,4	15,0	+	3,2	14,0

### **TYPICAL ALL WELD METAL MECHANICAL PROPERTIES:**

Deposited Hardness: 48 - 50 HRc

Work hardened: 53 HRc

Annealed 2h after welding at:

480°C: 51 HRc      600°C: 53 HRc      700°C: 48 HRc      760°C: 40 HRc

### **SCHWEISSPARAMETER:**

#### **PARAMETER:**

Diameter	Voltage	Amps
1,2	18 - 25	140 - 240
1,6	22 - 27	160 - 260
2,0	22 - 26	220 - 280
2,4	26 - 30	260 - 340
2,8	28 - 30	320 - 400

### **FORMS OF DELIVERY:**

Coil "BS 300" = 15 kg    |    Coil "BS 450" = 25 kg    |    Drums = 300 kg

OA = gasless, G = gas shielded, SA = Submerged Arc